

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016706**Date Inspected:** 10-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Splice 2W/3W Weld ID: ALS4 & ALS5
- 2). OBG Field Welding of Lower Lug Restoration between PP12 - PP13 - (SMAW)
- 3). OBG Field Welding of Studs to Edge Plate Weld B1 adjacent to 5W/6W - (SMAW)
- 4). OBG Field Splice 4W/5W Welds D2, Face B (FCAW-G)

- 1). OBG Field Splice 2W/3W Weld ID: ALS4 & ALS5

The QAI periodically observed AB/F approved welder Yao Xin Liang (ID 7238) performing grinding in the excavation on the face B side of ALS4 & ALS5. QC Inspector Tom Pasqualone was present and performed Magnetic Particle Testing (MT) of the excavations. The QAI observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. No welding was performed at this location on this date.

- 2). OBG Field Welding of Lower Lug Restoration between PP12 - PP13 - (SMAW)

The QAI periodically observed AB/F approved welder Rick Clayborn (ID 2773) performing CJP welding per the Shielded Metal Arc Welding (SMAW) process in the 2G (horizontal) and 4G (overhead) positions to restore a portion of the counter weight assembly lower lug at the edge plate at W1. See photo below. QC Inspector Mike Johnson was periodically present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1000.

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The QAI observed that the work appeared to be in general compliance with contract documents.

3). OBG Field Welding of Studs to Edge Plate Weld B1 adjacent to 5W/6W - (SMAW)

The QAI periodically observed AB/F approved welder Darcell Jackson (ID 9967) performing fillet welding per the Shielded Metal Arc Welding (SMAW) process in the 2F, 3F and 4F positions to repair and to attach Studs to the edge plate on the Counter Weight side of the OBG between. See photo below. QC Inspector Mike Johnson was periodically present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-F1200A. The QAI observed that the work appeared to be in general compliance with contract documents.

4). OBG Field Splice 4W/5W Weld ID: D2, Face B (FCAW-G)

The QAI periodically observed the in process welding of OBG Field Splice 4W/5W weld ID: D2 Face B per the Flux Cored Welding (FCAW-G) process in the 4G (overhead) position by ABF welding personnel Rory Hogan (ID 3186). QC Inspector Jim Cunningham was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-3040A-4. The QAI observed that the welding parameters obtained by Mr. Cunningham appeared to be in general compliance with the contract documents and were as follows: 248 amps, 24.5 volts and a travel speed measured as 192mm per minute. Welding was in process for the remainder of this shift.



Summary of Conversations:

Conversations on this date with Quality Control Inspectors were general in nature and pertained to locations of welding and QC activities.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

Inspected By: Madison,Bert

Quality Assurance Inspector

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Reviewed By: Levell,Bill

QA Reviewer